

Work Order ID 54850

December 30, 2009 7:42:02 AM

Page 1

Item ID: D2274

Accept

Setup Start

Revision ID:

Stop

Item Name: Radius Block

Start Date: 12/31/2009 Start Qty: 200.00

Cust Item ID:

Required Date: 1/6/2010 Req'd Qty: 200.00

Customer:

Reference:

Approvals: Process Plan: *mf* Date: 09-12-30 Tooling:

Run Start

QC: Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2274

Rev F

100

0.00

Shear

SHEAR

Memo

0.00

Shear

blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces

mf 10/01/03

110

0.00

HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio D2274

SP 10/01/09

234

120

0.00

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

SP 10/01/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

Sh 10/01/11

QC

Memo

0.00

Quality Control

140

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Tumble: Deburr any rough edges after tumbling

LT

EP 10/01/11 (234)

B10-1-12

(234)

150

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

BR 10-01-12 (234)

W/O:		WORK ORDER CHANGES					
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Start Date: 12/31/2009 Start Qty: 200.00



Cust Item ID:

Required Date: 1/6/2010 Req'd Qty: 200.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

JL

10-01-12

CSJ

©

170

Identify as per dwg & Stock Location: 10

0.00



Packaging

Memo

0.00

Packaging

10-1-12

2342 SF

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/13

MF 10-1-12

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Picklist Print

December 30, 2009 7:42:01 AM

Page 1

Work Order ID: 54850



Parent Item: D2274

Parent Item Name: Radius Block

Start Date: 12/31/2009

Required Date: 1/6/2010

Comments:

Start Qty: 200.00

Required Qty: 200.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B00750X00.1 25		Purchased	No			100	f	29.4100	19.2842			



6061-T6 Bar .750 x .125



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	29.41	
105061	3.4	
109760	6.01	
113216	20	

120 *ml* 10/01/03

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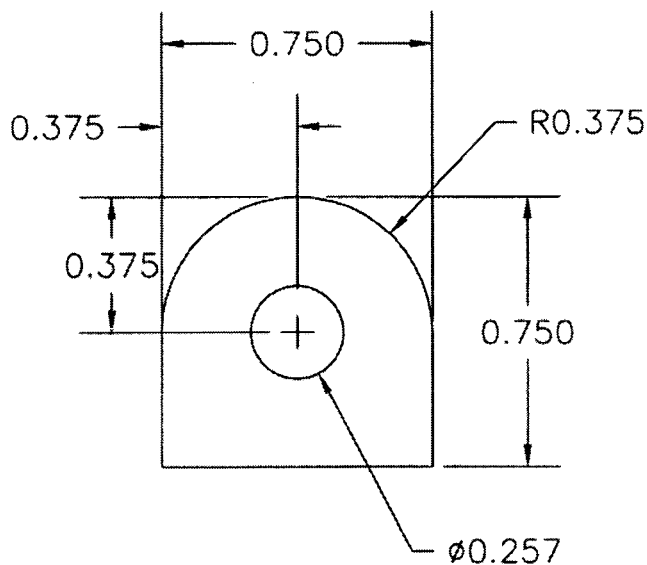
NOTE: Date & initial all entries



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
98/08/18 KE

#54850



00.05.16
00.05.16
0.063 x 45° CHAMFER
R0.0 - 0.13

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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